

Work Order ID 51746

September 1, 2009 10:53:19 AM



Page 1

Item ID: D3186-3

Accept



Setup Start



Revision ID: D

Stop



Item Name: Spacepod Door, LH

Start Date: 9/01/09 Start Qty: 1.00



Cust Item ID:

Required Date: 9/11/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3186

Rev D

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill holes and cut out latch slots per dwg D3186 (D3186-3 detail)

IT 09-09-09

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> S o r l o r l o r



120

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

9/9/11



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
9/9/9	100	Cut latch slots at 1.16 edge distance instead of 0.98.	EC 09.09 -09			09.09.09 851 642	S 09/09/09	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51746

September 1, 2009 10:53:19 AM



Page 2

Item ID: D3186-3

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Setup Start



Revision ID: D

Stop



Item Name: Spacepod Door, LH

Start Date: 9/01/09 Start Qty: 1.00



Cust Item ID:

Required Date: 9/11/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/11 JJ

u 9-09-11

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

September 1, 2009 10:53:18 AM

Page 1

Work Order ID: 51746

Parent Item: D3186-3RevD

Parent Item Name: Spacepod Door, LH

Comments:

Start Date: 9/01/09

Required Date: 9/11/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3186-1MRevD		Manufactured	No				Each	1.0000	1.0000			



SPACEPOD DOOR LH



87 09-09-09

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

45690A

1

1

48149 C01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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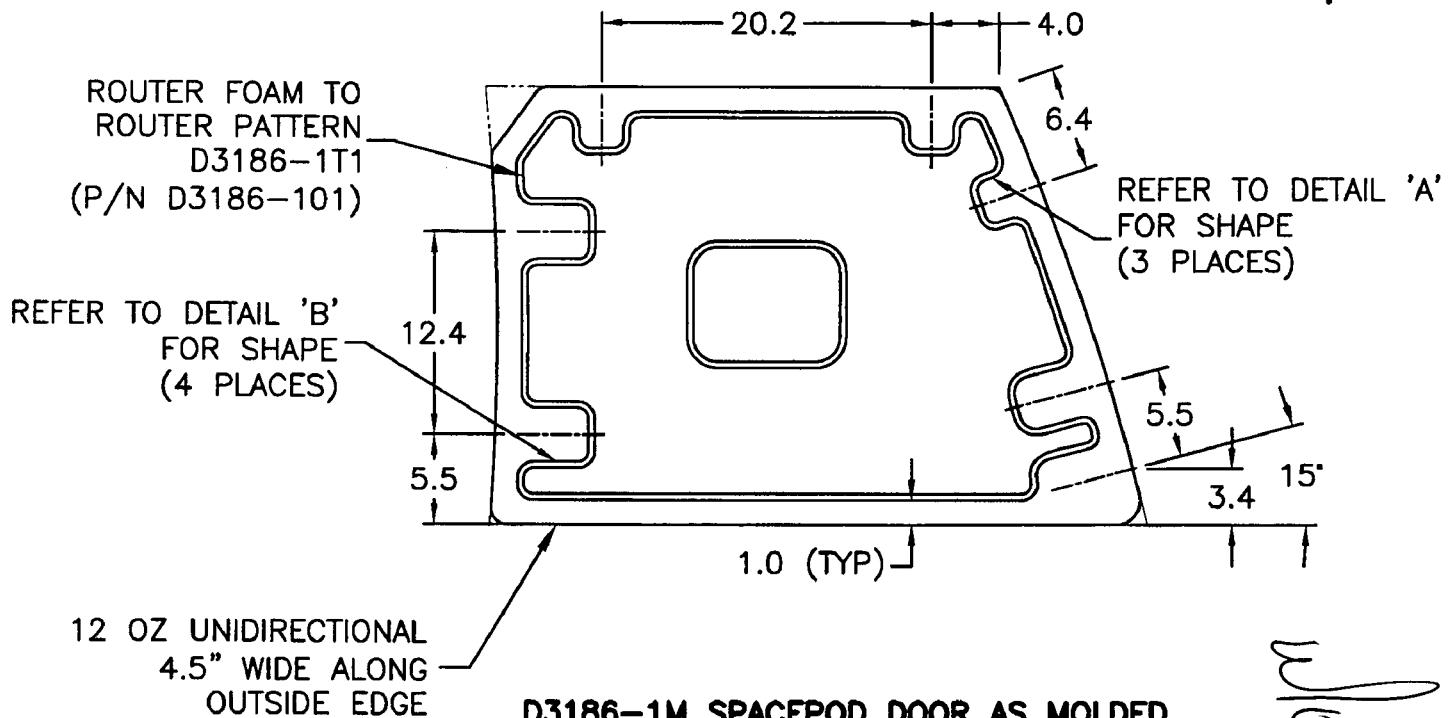
NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED07.02.27 *H***NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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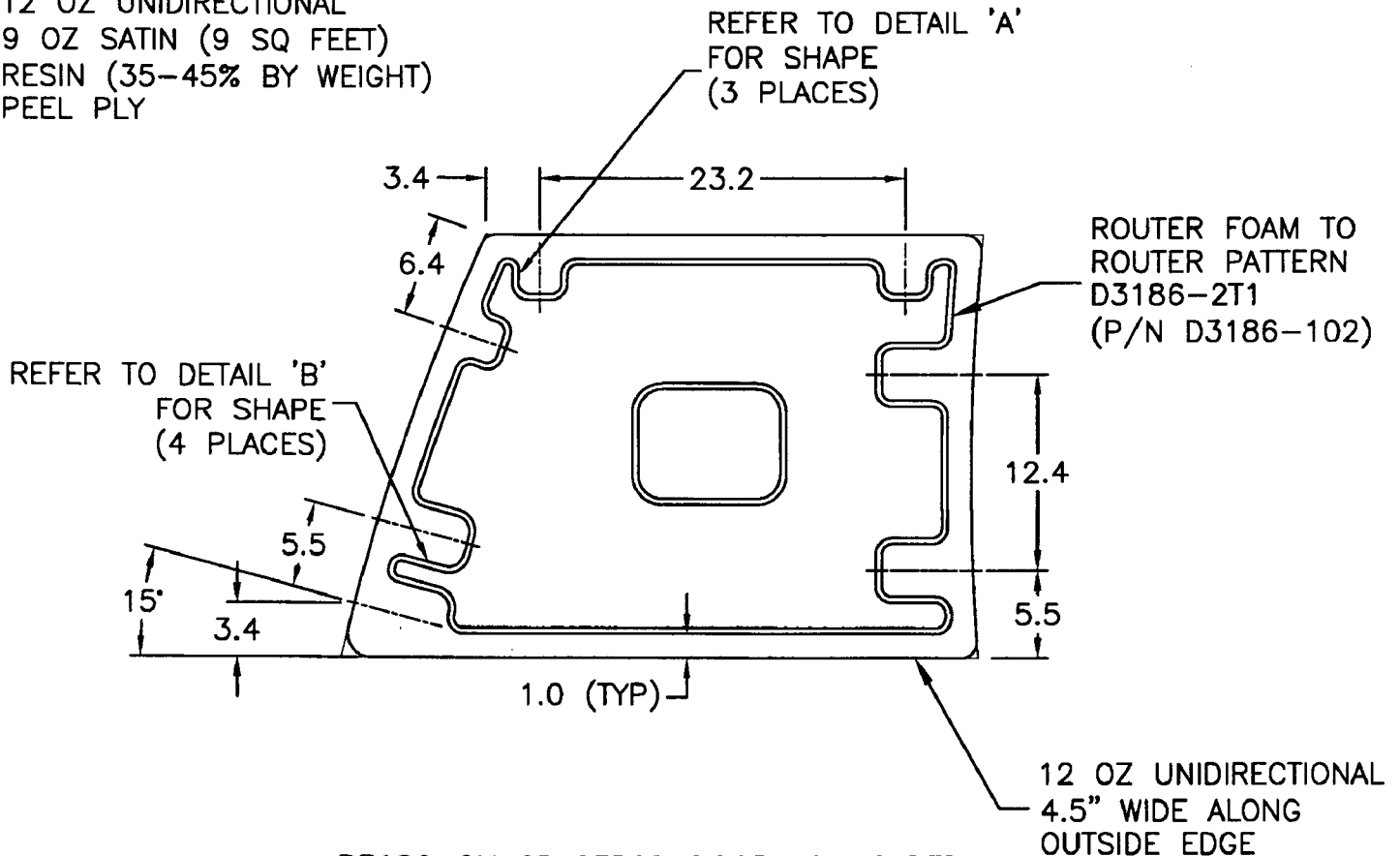
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED07.02.27 *[Signature]***NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
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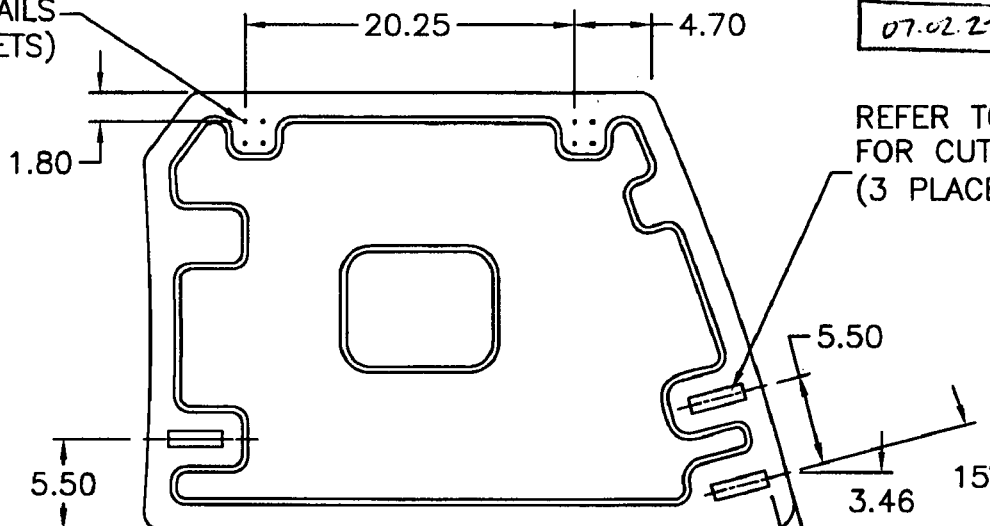
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

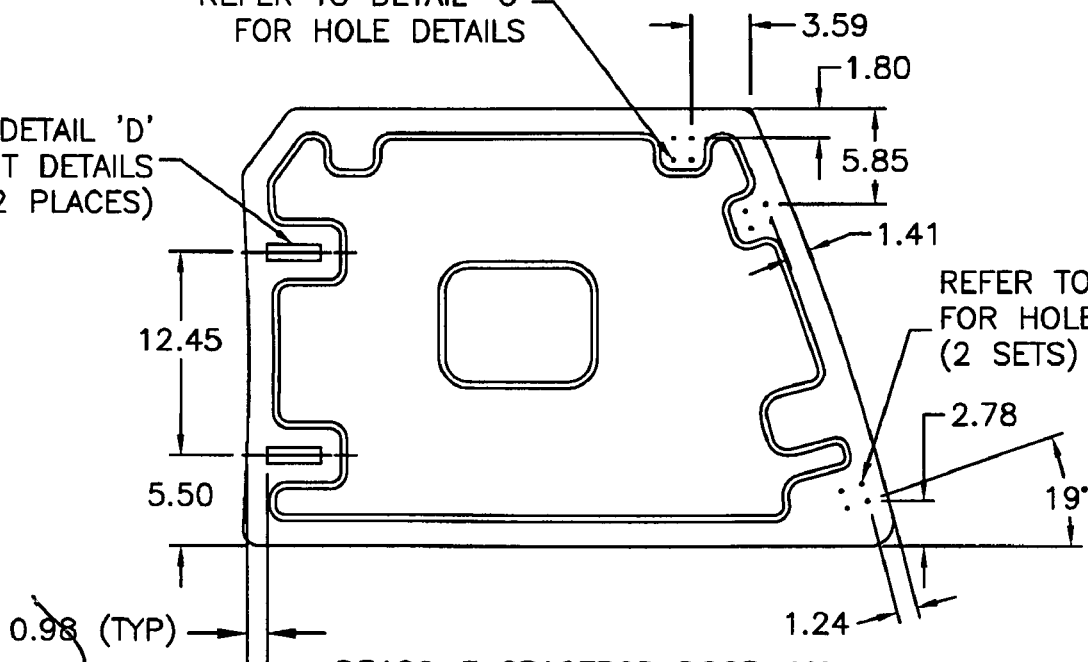
REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)



D3186-1 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)

REFER TO DETAIL 'C'
FOR HOLE DETAILS

REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(2 PLACES)



D3186-3 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)

NOTES:

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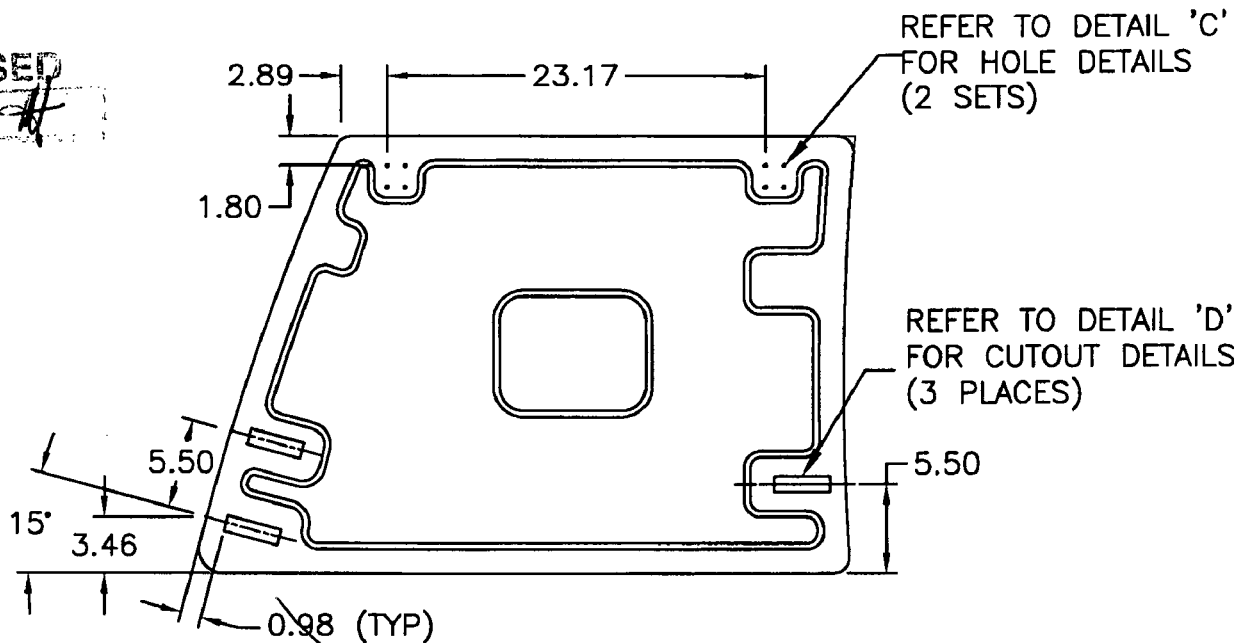
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DART

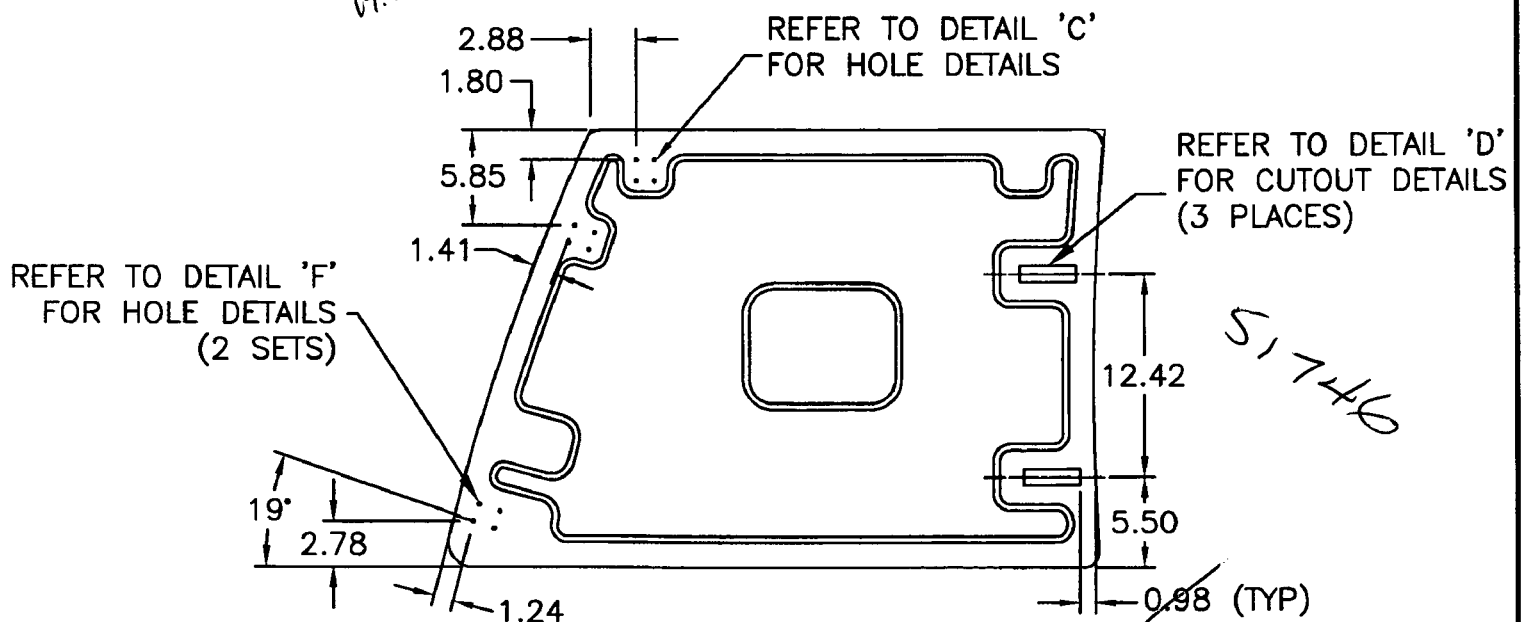
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 4 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED

07-02-27



D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

NOTES:

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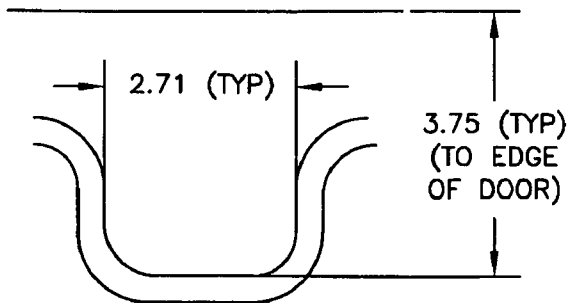
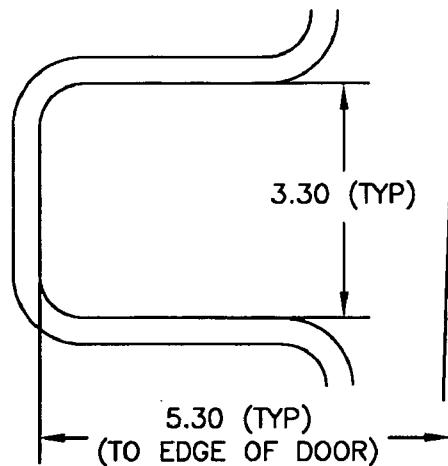
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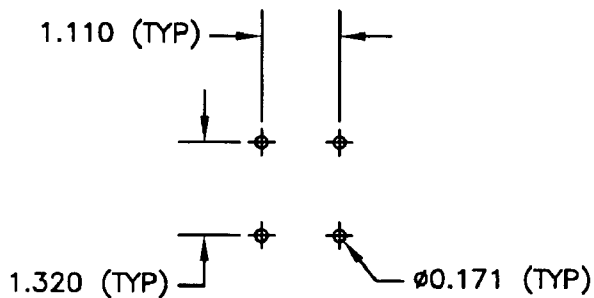
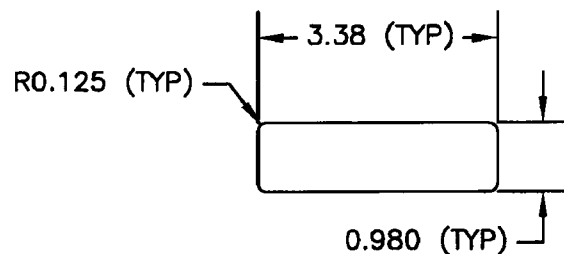
NOTE: Date & initial all entries

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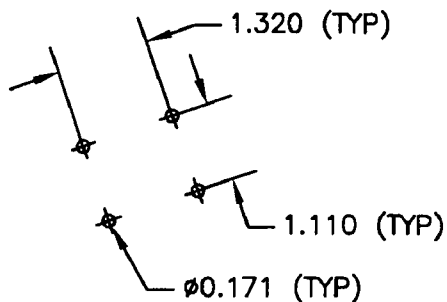
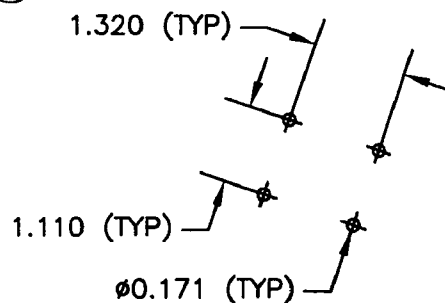
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**DETAIL A****DETAIL B****RELEASED**

07.02.27 [Signature]

**DETAIL C**

NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D**DETAIL E****DETAIL F****NOTES:**

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